

Date: Tuesday, 08/04/2008 4:50:43 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: LUG BRACKET		
Job Number	: 38455			Part Number	: D27351		
Estimate Number	: 10009			Drawing Number	: D2735 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 08/04/2008	S.O. No.	:	Drawing Revision	: C		
Prsht Rev.	: NC			Material			
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 25/04/2008	Qty:	40
Previous Run	: 37860			Um:	Each		
Written By	:			JLM			
Checked & Approved By	: JD 08.4.01			EC			
Comment	: Est Rev:C Removed from 9 Digit 05-10-25 est rev D waterjet 06.09.19						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S125	1010-1025 sheet .125
		Comment: Qty.: 0.1733 sf(s)/Unit Total : 6.9300 sf(s) 1010-1025 sheet .125 batch: 107513 HB 8-4-9
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D2735 (D2735-1) Dwg Rev: C HB 8-4-9 Prog Rev: C
		(45)
		2-Deburr if necessary HB 8-4-9
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		HB 8-4-9
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		S 08/04/10 (45) count
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE
		1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204
		2-Deburr if required.
		SB 08/04/24 (45)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 38455		Part Number: D27351
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP
		 <i>coates</i> S 08/04/24 (445)
Comment: INSPECT WORK TO CURRENT STEP		
7.0	PACKAGING 1	PACKAGING RESOURCE #1
		
Comment: PACKAGING RESOURCE #1		
Identify and Stock Location: SJ266		 C 08/24 (40-)
8.0	QC21	FINAL INSPECTION/W/O RELEASE
		 08/04/2890
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		 mf 08-04-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38455
Description: Lug Bracket	Part Number:	D2735-1
Inspection Dwg: D2735	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

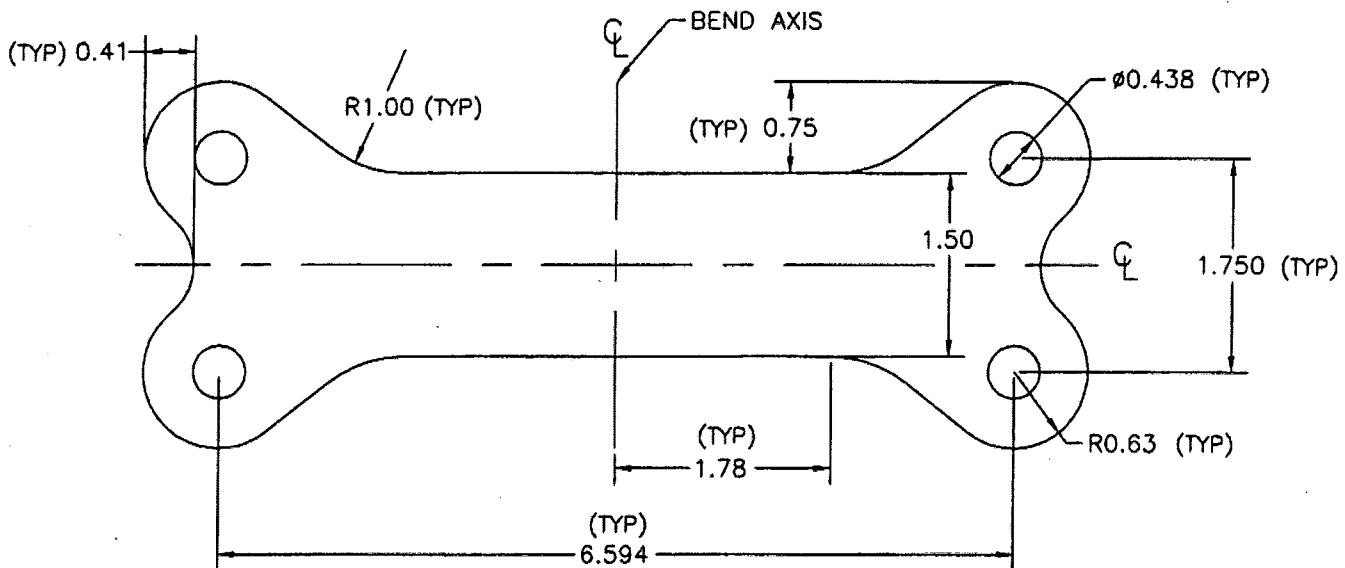
X First Article Prototype

Measured by:	<u>B</u>	Audited by:	<u>C</u>	Prototype Approval:	N/A
Date:	8-4-9	Date:	8/04/10	Date:	N/A

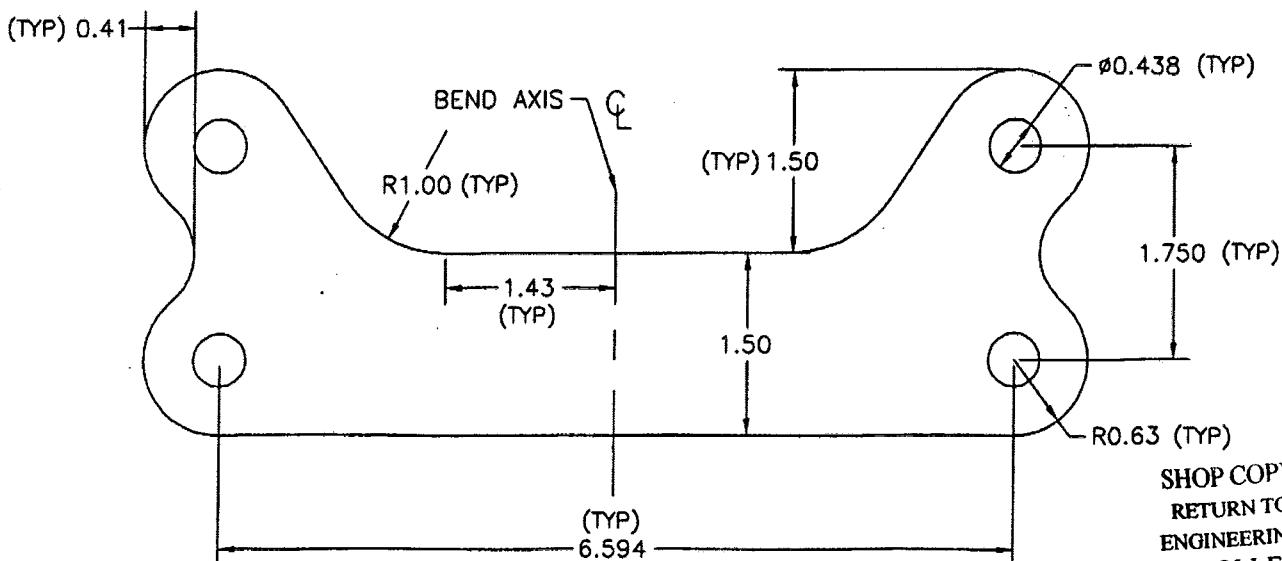
Rev	Date	Change	Revised by	Approved
A	07.02.02	New Issue	KJ/JLM	SJL

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2735
	KF	REV. C SHEET 1 OF 2
DATE		TITLE LUG BRACKET
98.12.14		SCALE 2:3
A	97.12.14	NEW ISSUE
B	98.10.23	UPDATE MATERIAL (TSR A1114)
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)

RELEASED
98.12.14 DS

D2735-1 FLAT PATTERN
SYMMETRIC ABOUT BOTH CENTRE-LINES (C)

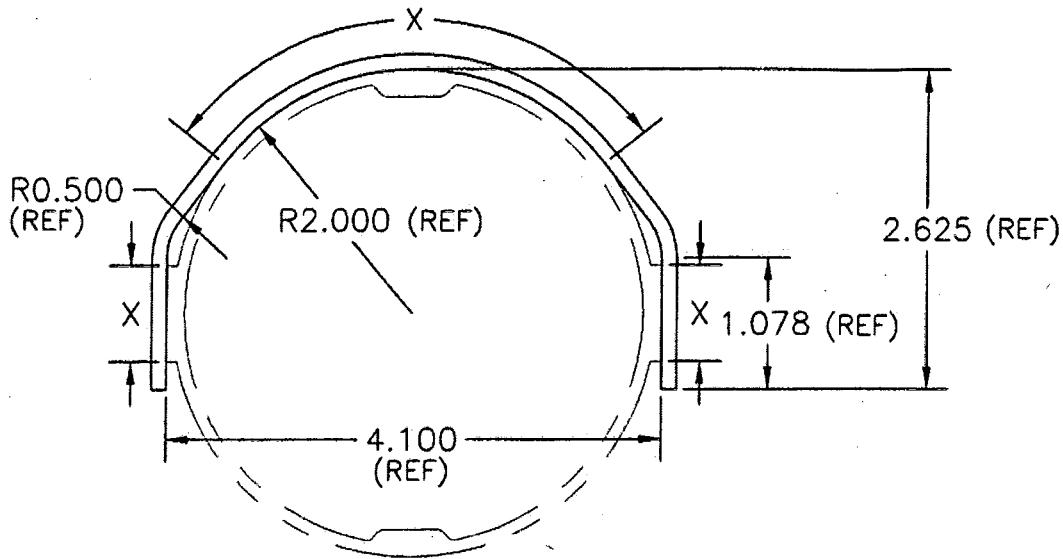


D2735-3 FLAT PATTERN
SYMMETRIC ABOUT CENTRE-LINE (C)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38455

DART

DESIGN <i>PF</i>	DRAWN BY <i>MM</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3

RELEASED
18.12.14 DSD2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.125 THICK (11 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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NO. *3845*